

D206-642-114

Dart Aerospace Ltd.

Date: Wednesday, 29/04/2009 10:15:56 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY, 206 A/B LOW
Job Number	: 47584A		
Estimate Number	: 13807		
P.O. Number	:	Part Number	: D206642151
This Issue	: 29/04/2009 S.O. No. :	Drawing Number	: D3804 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SKIDTUBES	Drawing Revision	: A
Previous Run	: 47583A	Material	:
Written By	:	Due Date	: 15/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>Julie Dawson 04.29</u>		
Comment	Est Rev:A 09-03-06 new issue DD verified by:EC Est Rev:B 09-03-10 add sub assembly D206-642-149 DD verified by:EC Est Rev:C 09-04-06 replace -147 as per ECN09-549 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

N/A *[Signature]*

2.0	D2620	Skidtube, 206 Skidtube
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	<u>45898</u>

25 09-05-07

3.0	D32861	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-1	Doubler	<u>46440</u>

25 09-05-07

4.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	<u>243846</u>

BE 09/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M110972/M109213 BE 09/05/07

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 (A,B & C).

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

15-Remove indexing edge using DT8741 as per Dwg D3804

16-C'sink GHW rivet holes as per Dwg D3804

} RT 09-05-07

BE 09/05/07

RT 09-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/08 (F)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to 0.3125"

2-Open Aft cap hole #6.

****no wearplate holes for this skidtube****

3-Deburr tube and blow out chips from inside the tube

}

RT 09-05-08

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RT 09-05-08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D 11 9--5-8

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

}

BE 09-05-11

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/11 (F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

m111127

184

BE

09/05/11

09/05/05

13.0

D26541

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

batch:

B47680

BE 09/05/11

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

BE 09/05/11

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 09/05/11

Time: 3:30

Finish Date: 9/5/12

Time: 8:00AM

BE 09/05/11

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

m11081

Sikaflex expire date:

01/2010

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/12

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty Part Number Description Batch

19 D2649

Crossbolt spacer

B45317

BE 09/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B43862

BE 09-05-12

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m109213

BE 09/05/12

2-Grind welds flush as per Dwg D3804.

u 9-5-12

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod

NOVE BE 09-05-12

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

pm 09-05-12 (2)

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m11548

pm 09-05-13 (2)

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch: *m11548*

pm 09-05-13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #: Machine Or Operation: Description :

21.0 D2680041 Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B33041

Pm: 09-05-13 (2)

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm: 09-05-13 (2)

23.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

09/05/13 (X)

24.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09/05/13 (X)

25.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

PR 09-05-15 (1)

26.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME:

10:15

OVEN TEMPERATURE:

300°

FINISH TIME:

10:45

cmd

09/05/15

27.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/06/04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

28.0	D3805041	Wearplate Assembly Fwd, Low Gear
------	----------	----------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate Assembly Fwd, Low Gear
batch: B47723

MD 09/06/04

29.0	D3805045	Wearplate Assembly Aft, Low Gear
------	----------	----------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate Assembly Aft, Low Gear
batch: B47724

MD 09/06/04

30.0	AN337A	Bolt
------	--------	------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Bolt
batch: M105425

MD 09/06/04

31.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Washer
batch: M105442

MD 09/06/04

32.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Nut
batch: M110884

MD 09/06/04

33.0	D38731	Bushing
------	--------	---------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Bushing
batch: B46757

MD 09/06/04

34.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
batch: M108161

MD 09/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D26511

Plug



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2651-1 Plugs B43990

MD 09/06/04

36.0

D26513

O-Ring



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2651-3 O-Rings B43849

MD 09/06/04

37.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M109061

MD 09/06/04

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- install RUN-ON LANDING WEARPLATE KIT as per dwg

2- Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804.

Clean excess adhesive.

MD 09/06/04

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B46327

MD 09/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M110467

MD 09/06/04

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M109632

MD 09/06/04

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M11108

Sikaflex expire date: 10/20

MD 09/06/04

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M111013

MD 09/06/04

(X1)

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Schubert (X)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

inspect for foreign objects as per QSI 024

Schubert (X)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP 47584

9/6/11

(K) SD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:15:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY, 206 A/B LOW

Job Number: 47584A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Li 09/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

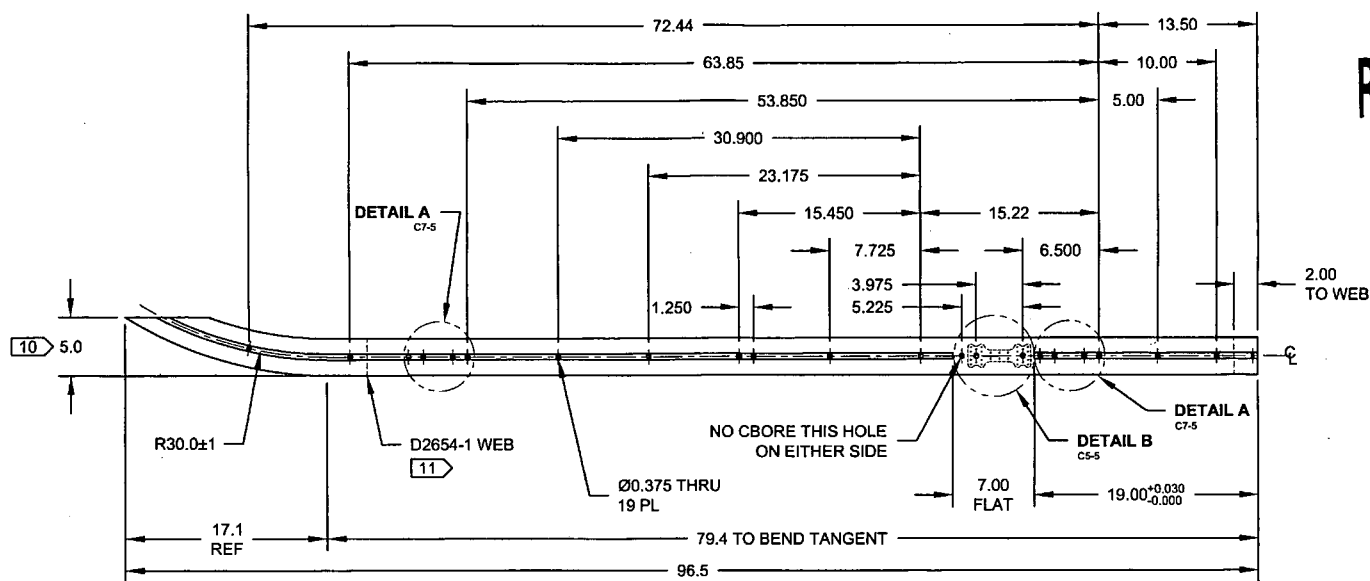
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
 09.03.03
 per ECN 09-536

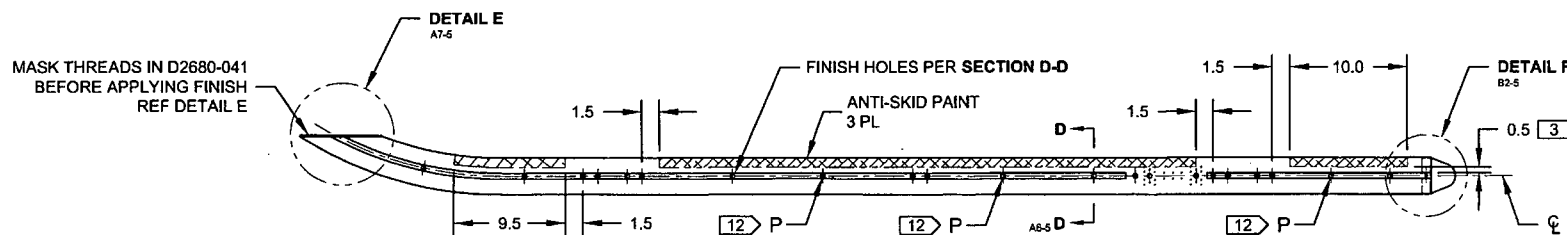
A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	93	DART AEROSPACE USA, INC	
DRAWN	93	PORT HADLOCK, WA	
CHECKED	93	DRAWING NO.	REV. A
MFG. APPR.	93	D3804	SHEET 1 OF 5
APPROVED	93	TITLE	SCALE
DE APPR.	93	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

NO. 15847A
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL

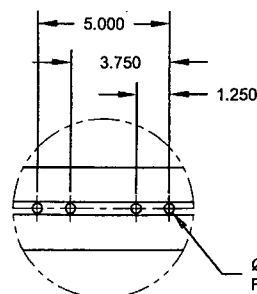


D3804-041 ASSEMBLY/FINISHING DETAIL

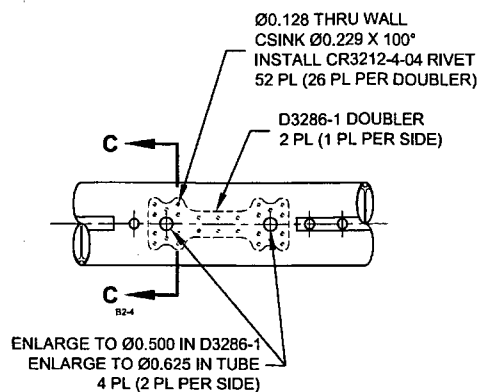
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 2 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

WITHOUT NOTICE
WORK ORDER NO. 2258419
UNCONTROLLED COPY
ENGINEERING
REF TO
SHOP COPY
SUBJECT TO AMENDMENT

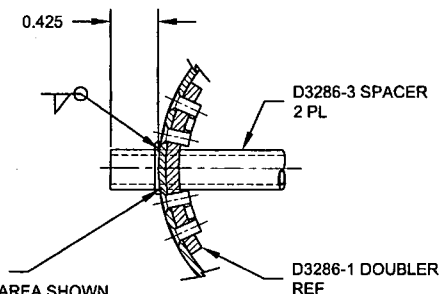
RELEASED
09.03.03



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

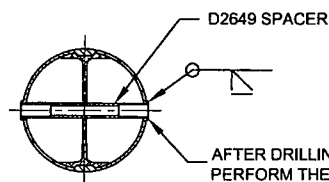


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-1



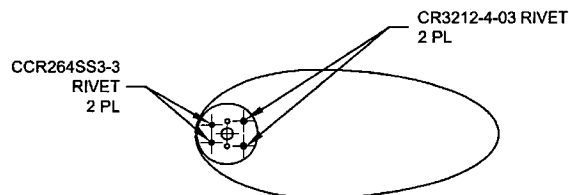
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	9	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 4 OF 5
APPROVED	9	TITLE	SCALE
DE APPR.	H	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

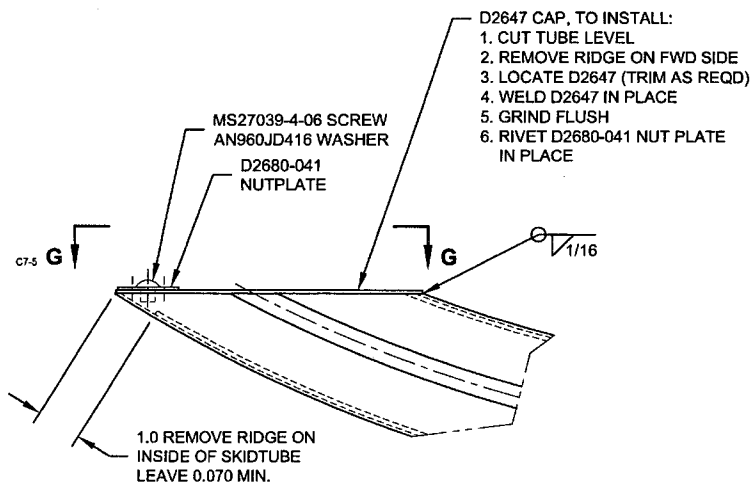
WORK ORDER
NO. 425849
WITHOUT NOTICE
SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

RELEASED
97 09.03.03



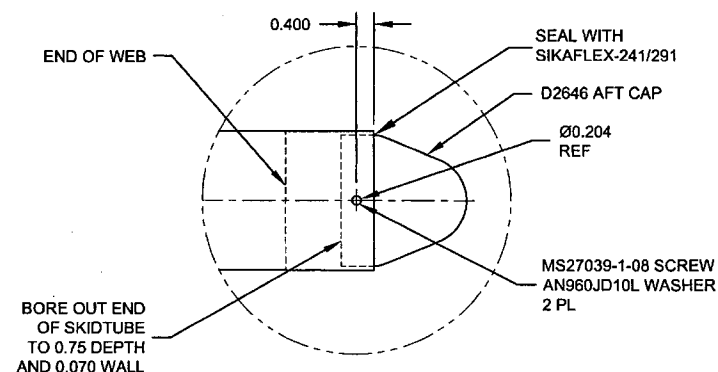
VIEW G-G
SCALE NONE

A7-5



DETAIL E
SCALE NONE

B7-2
B7-3



DETAIL F
SCALE NONE

B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

NO. 48807
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NO. 198

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 47288A
Part number: D206 642 545
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

UNACCEPTABLE

Cracks:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier P. D. [Signature] Date of Test Coupon 09.04.27
Welder Barclay Elliott Date of Test Coupon 09.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld